

Date: Thursday, 1/18/2007 3:20:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B AFT X-TUBE
 Job Number : 30316
 Estimate Number : 12347
 P.O. Number : N/A Part Number : D206667201
 This Issue : 1/18/2007 S.O. No. : N/A Drawing Number : D206-667-241 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B
 Previous Run : 30315 Material : N/A
 Due Date : 1/30/2007 Qty: 1 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est Rev: F05.09.01 Add holes for compatibility with Bell
 Skidtubes KJJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-201 CHG002

07.01.19

KJ.

2.0

D6003102

Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6003-102 Crosstube 23967

Check OD = 2.250"; ID = 1.380"

MS 07/01/21

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084

2-Turn first side as per Folio FA084

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241. MS 07/01/21

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/01/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/18/2007 3:20:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 30316

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA084

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241

Inside of Cuff(Donot engrave on outside of tube)

MS 07/01/22 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/01/22 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BC 07/01/22 1

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

DP 7-1-22 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-1-23

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP 7-1-23

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT

DP 7-1-23

W/O:		WORK ORDER CHANGES					
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Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/01/31

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576.
(DRILL 3 HOLES ON BOTH SIDES)

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.

4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs.
(DRILL 3 HOLES ON BOTH SIDES)

6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788

7-C'sink holes as per Dwg D206-667-241

8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241

EL/85
07/01/31

07-02-01

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT/R 070201

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

207-02060

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207-02060

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 206B AFT X-TUBE

Job Number: 30316

Part Number: D206667201

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3046

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 207102106 ①

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C 7/2/20

19.0 QC6 DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

20702-20 ①

20.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes *N/A*

2-Prime inside and outside crosstube as per QSI 005 4.2

ml 07 02 21

①

3-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 07 02 26

①

21.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

20702-22 ①

22.0 D2856400 Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total: 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

29285

85 07-03-06

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Drawing Name: 206B AFT X-TUBE

Job Number: 30316

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2891-1

Support

29086

KT 07-03-06

24.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-22

Clamp

102787

KT 07 03 06

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579.

2-Install supports and clamps as per Dwg D206-667-241. Torque clamps to 80-100 in lb

KT 07 03 06

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

KT 07 03 06

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

KT 7/3/11B

28.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

M103338

29.0

D2872043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2872-043

Nut Plate

324151

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206B AFT X-TUBE

Job Number: 30316

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2872045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2872-045

Nut Plate

B24152 ✓

31.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-10A

Description Batch

Bolt

M103389 ✓

32.0

AN530A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-30A

Description Batch

Bolt

M102083 ✓

33.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:Packing Kit

Qty Part number

20 AN960JD516

Description Batch

Washer

M102928 ✓

34.0

MS21042L5

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 MS21042L5

Description Batch

NUT

M100569 ✓

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C. Bat 1/13

SB 07/03/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/03/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/18/2007 3:20:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 30316

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-201

Location: 6

PPP Rev: 6

Handwritten signature and date: 07/03/13 SD

Handwritten signature: U

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten circled 1 and date: 07/03/14

Job Completion



Handwritten signature and date: U 07.03.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 30316
Description: Crosstube Assembly	Part Number: D206-667-241
Inspection Dwg: D206-667-241 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

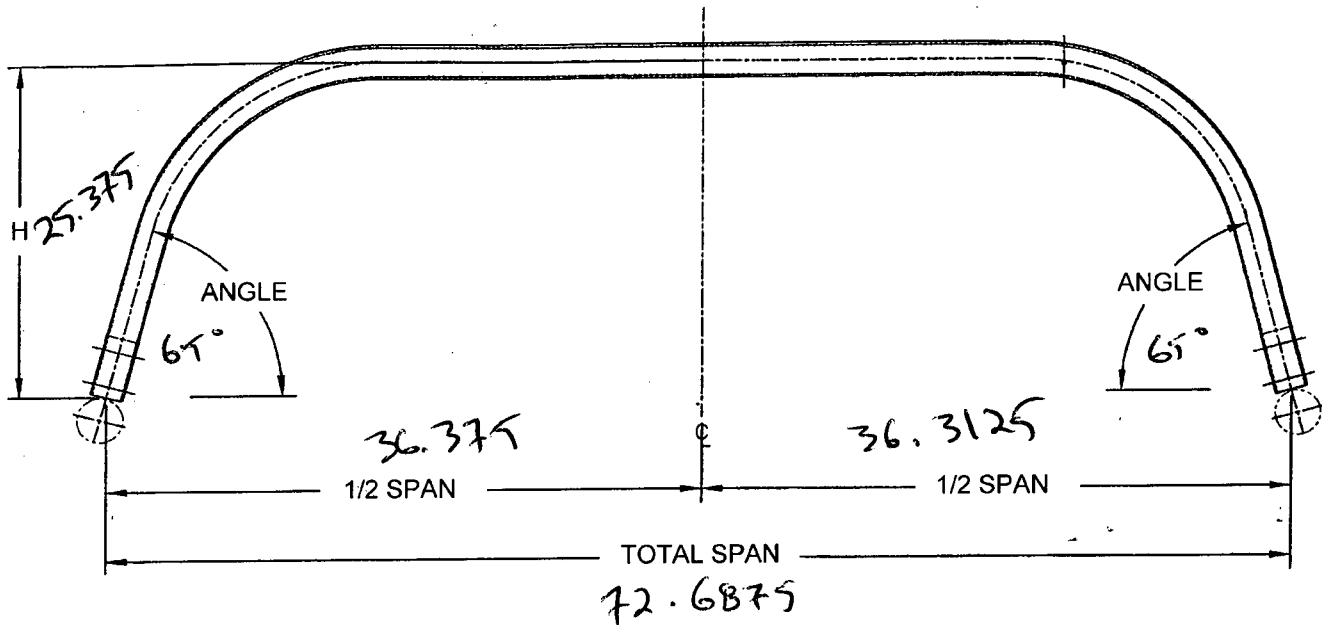
☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	30° X.500	✓			
	0.250	+/-0.010	.250	✓			
	2.240	+0.005/-0.000	2.243	✓			
	4.438	+/-0.030	4.440	✓			
	1.780	+0.005/-0.000	1.784	✓			
	R0.063	+/-0.010	.063	✓			
	1.851	+0.005/-0.000	1.855	✓			
	1.928	+0.005/-0.000	1.932	✓			
	2.005	+0.005/-0.000	2.009	✓			
	2.082	+0.005/-0.000	2.086	✓			
	2.159	+0.005/-0.000	2.162	✓			
	2.190	+0.005/-0.000					
SIDE B	30° x 0.500	+/-0.010	30° X.500	✓			
	0.250	+/-0.010	.250	✓			
	2.240	+0.005/-0.000	2.243	✓			
	4.438	+/-0.030	4.440	✓			
	1.780	+0.005/-0.000	1.783	✓			
	R0.063	+/-0.010	.063	✓			
	1.851	+0.005/-0.000	1.855	✓			
	1.928	+0.005/-0.000	1.932	✓			
	2.005	+0.005/-0.000	2.009	✓			
	2.082	+0.005/-0.000	2.086	✓			
	2.159	+0.005/-0.000	2.163	✓			
	2.190	+0.005/-0.000	2.193	✓			
	100.60	+/-0.020	100.60	✓			

Measured by: MS	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/01/22	Date: 0201.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM [Signature]	[Signature]

Crosstube Bend Dimension Sheet



PART NUMBER: 0206 - 667-201

BATCH NUMBER: 30316

DRAWING: 0206 CCF 241 REVISION: B

H: 25.04

1/2 SPAN: 36.6

TOTAL SPAN: 73.2

ANGLE: 65°

QC 15: MA
 DATE: 07/01/31
 QTY: ①

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-667-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-06-16 #

Qty	Part Number	Description
X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
1	D6003-102	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

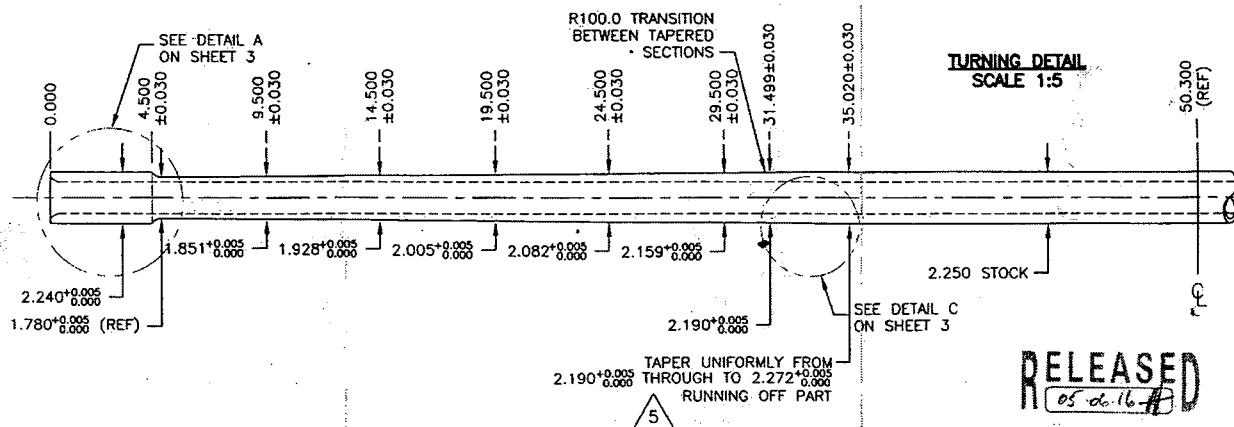
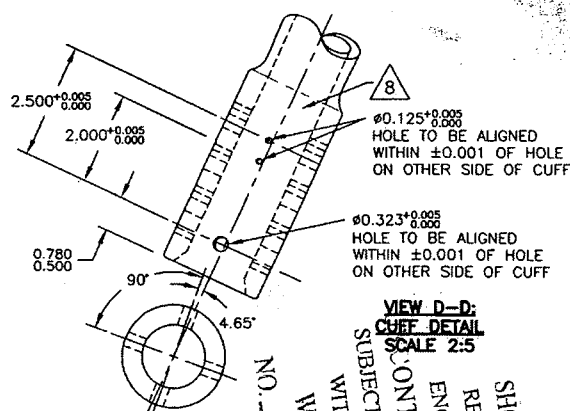
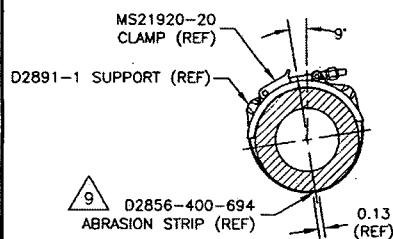
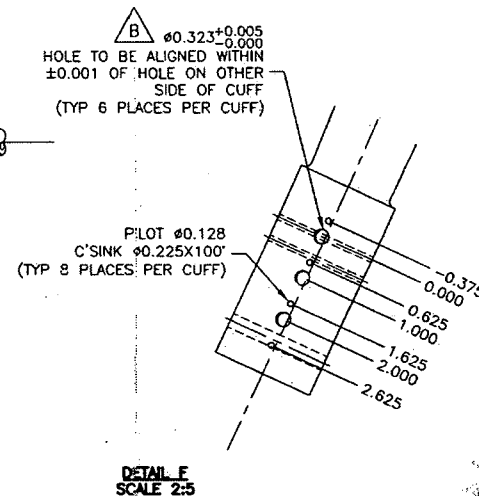
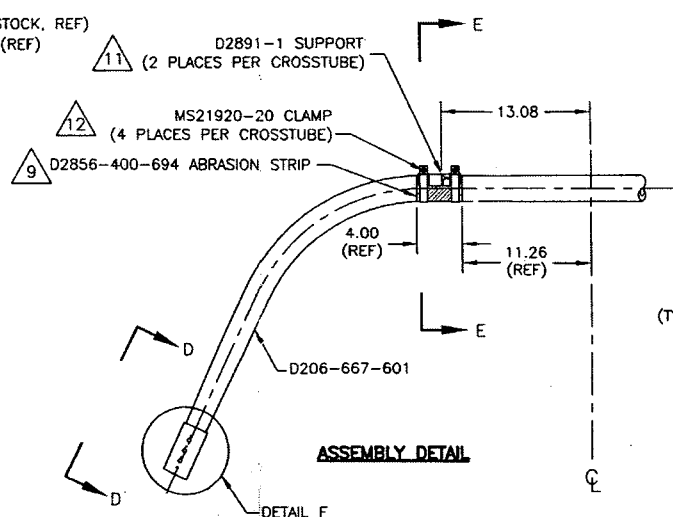
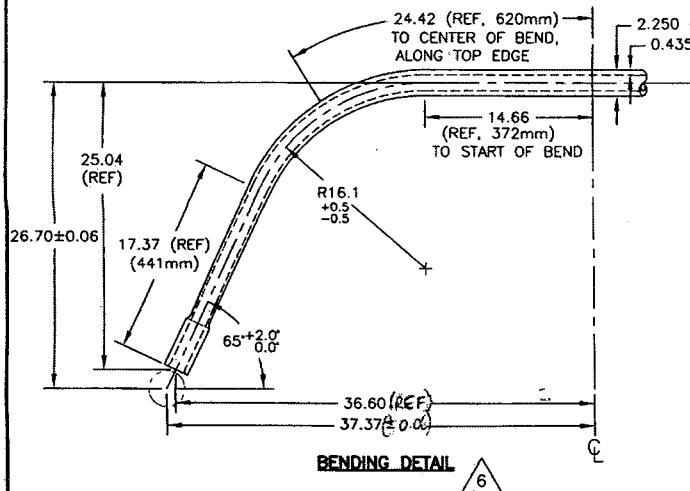
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30316

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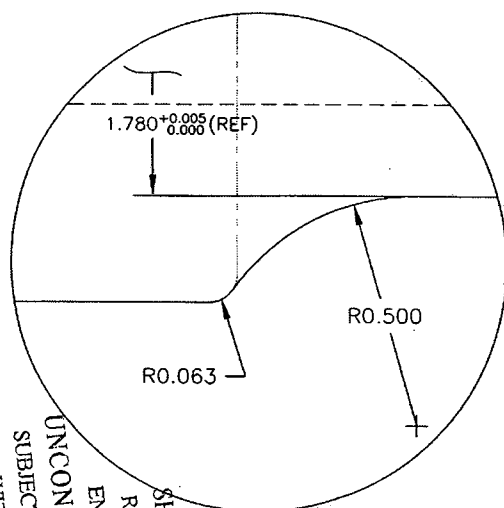
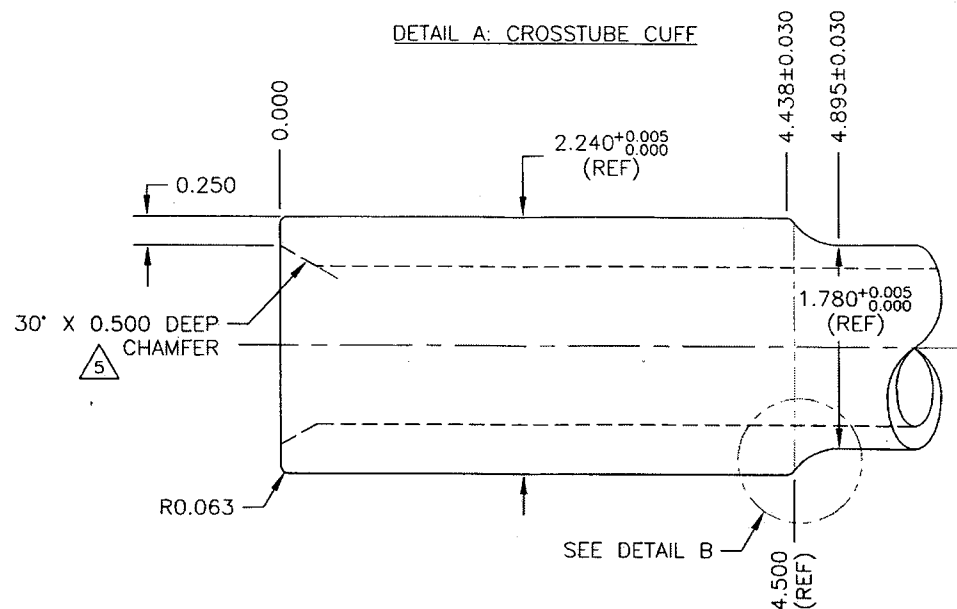
RELEASED
05-06-16

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #	APPROVED #	DRAWING NO. D206-667-241	REV. B
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT)		SHEET 2 OF 3 SCALE 1:10	

NO. 30316
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

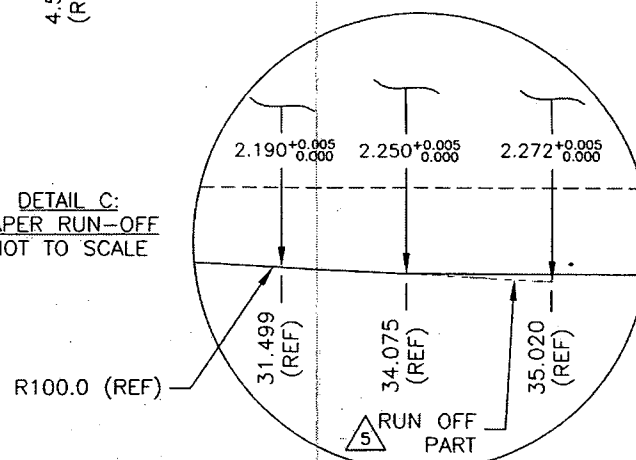
RELEASED
05-06-16

DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN

PH

DRAWN BY

PH

CHECKED

#

APPROVED

#

DATE

05.02.04

DART

DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA

DRAWING NO.

0206-667-241

REV. B

SHEET 3 OF 3

TITLE

CROSSTUBE ASS'Y (206B HIGH AFT)

SCALE
1:1

NO. 30316
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35707

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (10) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (4) P/N D206-667-101 S/N's B29099, B28680, B29101 and B26864.

Qty (4) P/N D206-667-201 S/N's B30316, B30319, B29098 and B29096.

Qty (2) P/N D407-667-205 S/N's B26323 and B28983.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (10) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(10) cross tubes inspected. (6) PASSED / (4) FAILED.

Details: Failed S/N's B29099, B28680, B29101 and B29098.

- tubes are marked at locations requiring rework.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE February 12, 2007

INSPECTION
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003046

ADDRESS:

CONTACT NAME: Linda Lacey

LABOUR

② F. (613) 632-1053

\$

MATERIALS

②

TRAVEL EXPENSES

②

GST

HOTEL EXPENSES

②

PST

INVOICE NO.

TOTAL \$